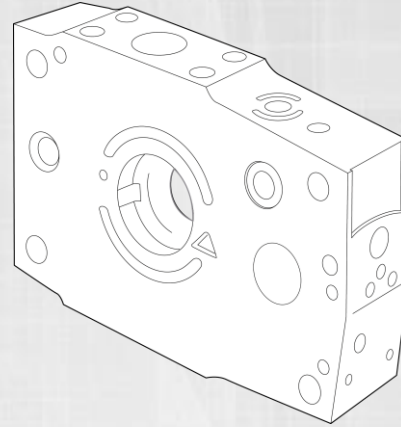


## Application example

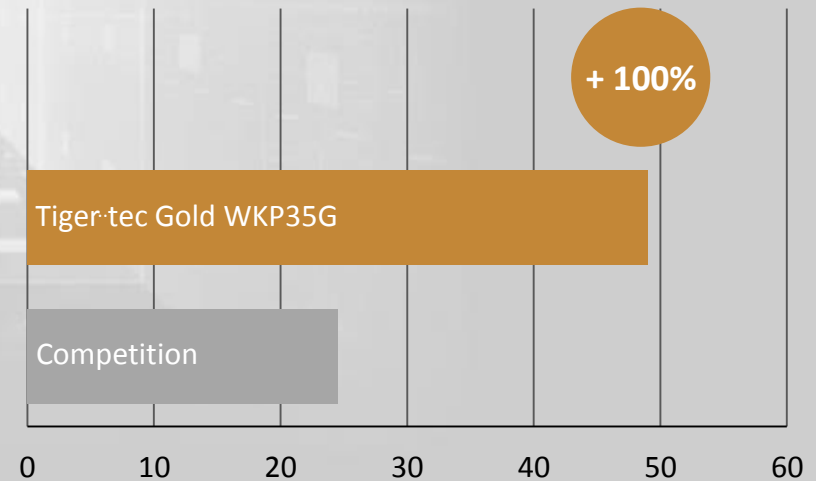
### Heptagon- Face mill M3024



Work piece	Hydraulic plate
Material	EN-GJS600-3, ISO-K
Operation	Face milling
<b>Tool</b>	<b>M3024-080-B27-06-04</b>
<b>Insert</b>	<b>XNMU070508-F57</b>
<b>Grade</b>	<b>WKP35G</b>

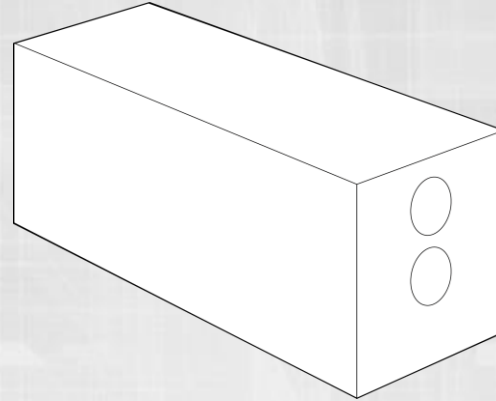
		Competition	Walter
<b>Z</b>	Number of teeth	6	6
<b>v<sub>c</sub></b>	[m/min]	220	220
<b>f<sub>z</sub></b>	[mm]	0,26	0,26
<b>v<sub>f</sub></b>	[mm/min]	1.365	1.365
<b>a<sub>p</sub></b>	[mm]	3	3
<b>a<sub>e</sub></b>	[mm]	55	55

Comparison: Tool life [min]



## Application example

### Face mill M4003



Work piece	Basic body
Material	31CrMoV9; ISO-P
Operation	Finishing the surface
<b>Tool</b>	<b>M4003-125-B40-13-6.5</b>
<b>Insert</b>	<b>SDGT1204AZN-F57</b>
<b>Grade</b>	<b>WKP35G</b>

		Competition	Walter
<b>Z</b>	Number of teeth	9	12+1*
<b>v<sub>c</sub></b>	[m/min]	275	275
<b>f<sub>z</sub></b>	[mm]	0,19	0,18
<b>v<sub>f</sub></b>	[mm/min]	1.201	1.600
<b>a<sub>p</sub></b>	[mm]	0,5	0,5
<b>a<sub>e</sub></b>	[mm]	100	100

\*SDHX1205AZR-A88 WHH15

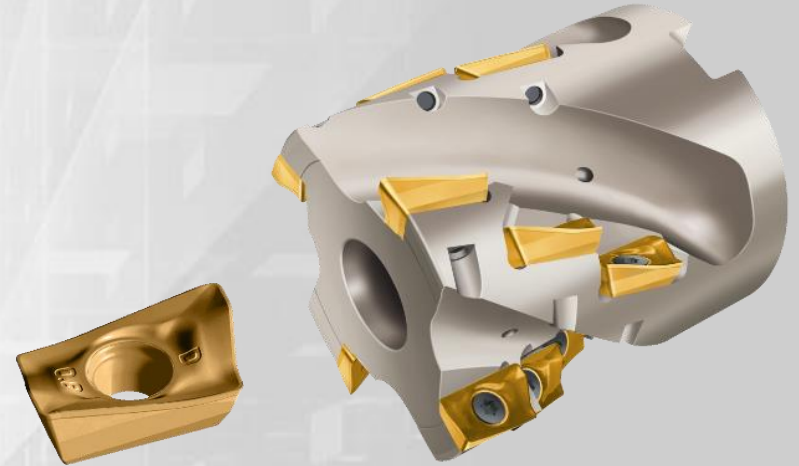
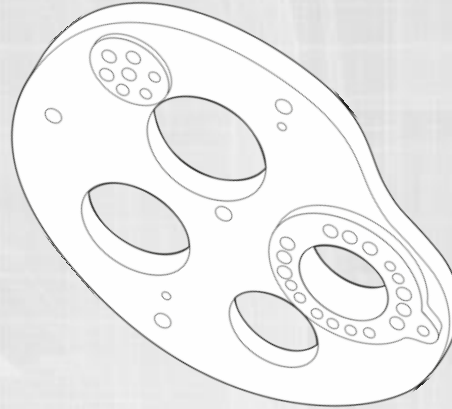


Comparison: Tool life [pieces]



## Application example

### Helical mill F4238



Work piece	Cam
Material	EN-GJS-1000-5 (GGG 100)
Operation	Trimming
Tool	<b>F4238.B32.080.Z05.57</b>
Insert	<b>ADMT160608R-D56</b>
Grade	<b>WKP35G</b>

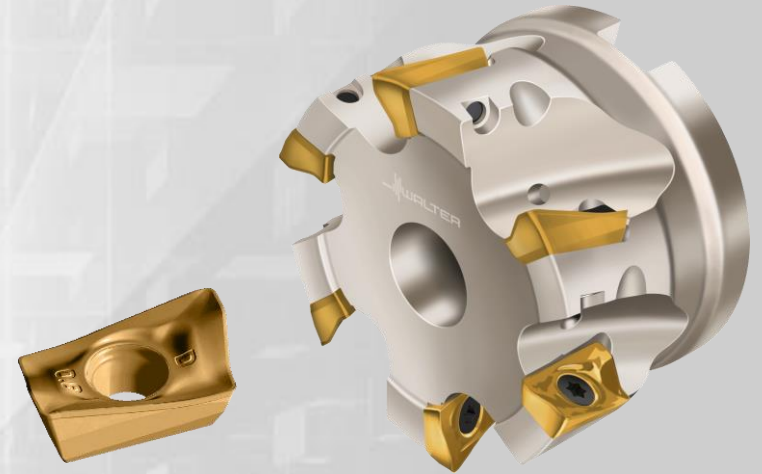
		Competition	Walter
<b>Z</b>	number of teeth	5	5
<b>v<sub>c</sub></b>	[m/min]	90	90
<b>f<sub>z</sub></b>	[mm]	0,175	0,175
<b>v<sub>f</sub></b>	[mm/min]	315	315
<b>a<sub>p</sub></b>	[mm]	30	30
<b>a<sub>e</sub></b>	[mm]	6 - 10	6 - 10

Comparison: Tool life [min]



## Application example

### Shoulder mill F4042



Work piece	Beam
Material	St37-3 (1.0116), ISO-P
Operation	Shoulder milling
<b>Tool</b>	<b>F4042.B32.100.Z08.15</b>
<b>Insert</b>	<b>ADMT160608R-D56</b>
<b>Grade</b>	<b>WKP35G</b>

	Competition	Walter
<b>Z</b> number of teeth	<b>7</b>	<b>8</b>
<b>v<sub>c</sub></b> [m/min]	<b>220</b>	<b>220</b>
<b>f<sub>z</sub></b> [mm]	<b>0,17</b>	<b>0,17</b>
<b>v<sub>f</sub></b> [mm/min]	<b>812</b>	<b>952</b>
<b>a<sub>p</sub></b> [mm]	<b>5</b>	<b>5</b>
<b>a<sub>e</sub></b> [mm]	<b>66</b>	<b>66</b>

Comparison: Tool life [min]

